

Work Order ID 151944

Friday, October 14, 2016 1:55:47 PM

151944

Page 1

Item ID: D3290-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window
Start Date: 10/6/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 17 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.05
FLOW CNC Waterjet 1-Cut as per Dwg D3290 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(4) OK 10/10/24

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.01
Quality Control

(4) OK 10/10/24

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.01
Quality Control

(4) **DAS 38 9-89**
OCT 25 2016

Friday, October 14, 2016 1:55:47 PM

Page 2

Visually inspect part for proper formation & texture

Work Order ID 151944

Friday, October 14, 2016 1:55:47 PM

151944

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo 1) Water sand and buff to remove scratches if required 2) Engrave P/N "D3290-3" and B/N on lower edge. Use 0.125" high letters to maximum depth of 0.005"	0.00 0.04				4			DAS 07 9-89 16/11/03
175 *175* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				4			DAS 07 9-89 16/11/03
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				4			DAS 16 9-89 16/11/03

Work Order ID 151944

Friday, October 14, 2016 1:55:47 PM

151944

Page 4

Item ID: D3290-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window

Start Date: 10/6/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>Sf432</u>	0.00							
190									
Packaging	Memo	0.01				4			DAS 6 9-89
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							
Quality Control									

NOV 09 2016

16/11/9
2m 16/11/9

Picklist Print

Friday, October 14, 2016 1:55:47 PM

Page 1

Work Order ID: 151944

151944

Parent Item: D3290-3

D3290-3

Parent Item Name: Window

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.08.18New issueKJ/RF
 IPP B06.05.09Ecn 798 EC IPP Rev.
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29. Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	104.6500	3	12.63158			

MACRI ICS 125

1/8" Polycast II Sheet

14

22/10/27

Location

Loc Qty

Loc Code

MAT019

104.65

m131524

8.95

m134641

12

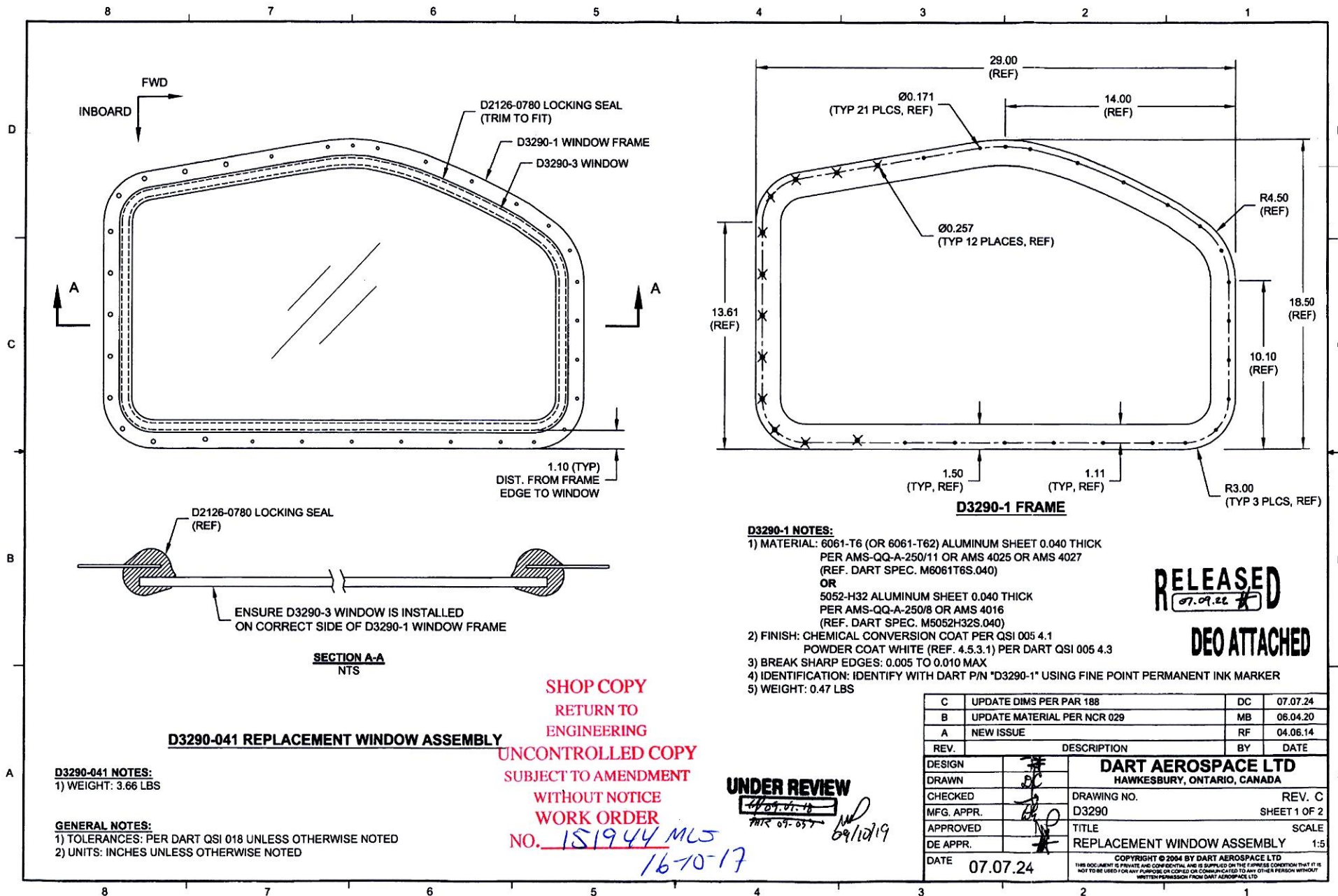
m135555

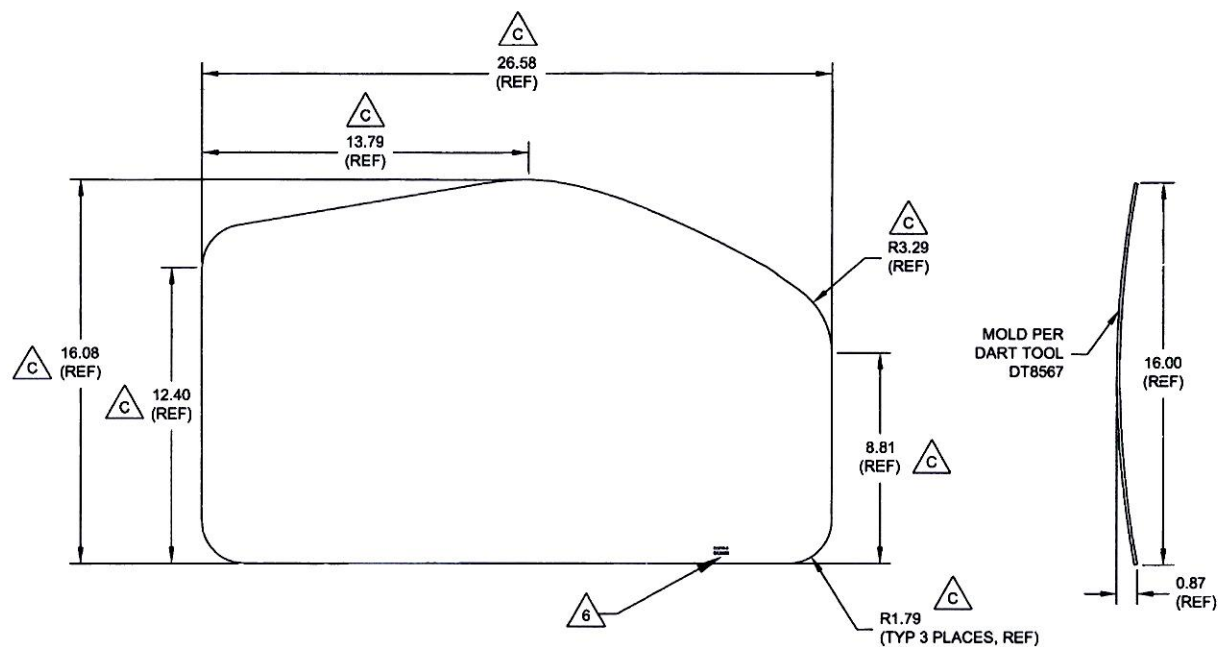
83.7

3.5

3.5

3.5





D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

W. J. H. 10/18
UNDER REVIEW
10/18
DEO ATTACHED
RELEASED
07.07.22

DESIGN	<i>DF</i>	DART AEROSPACE LTD
DRAWN	<i>DF</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DF</i>	DRAWING NO. REV. C
MFG. APPR.	<i>DF</i>	D3290 SHEET 2 OF 2
APPROVED	<i>DF</i>	TITLE SCALE
DE APPR.	<i>DF</i>	REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>h</i>	MFG. APPR. <i>FE</i>	APPROVED <i>MD</i>		DE APPR. <i>h</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
MD